



TECHNICAL

TAP DRILL SELECTION

Tap Size	Tap Drill Size	Decimal Equiv. of Tap Drill (Inches)	Theoretical Percent of Thread	Probable Mean Oversize (Inches)	Probable Hole Size (Inches)	Probable Percent of Thread
0-80	56	.0465	83	.0015	.0480	74
	3/64	.0469	81	.0015	.0484	71
1-64	54	.0550	89	.0015	.0565	81
	1.45 mm	.0571	78	.0015	.0586	71
1-72	1.5 mm	.0591	77	.0015	.0606	68
2-56	53	.0595	75	.0015	.0610	67
	51	.0670	82	.0017	.0687	74
2-64	50	.0700	69	.0017	.0717	62
	50	.0700	79	.0017	.0717	70
3-48	1.80 mm	.0709	74	.0017	.0726	66
	48	.0760	85	.0019	.0779	78
3-56	5/64	.0781	77	.0019	.0800	70
	46	.0810	78	.0019	.0829	69
4-40	45	.0820	73	.0019	.0839	65
	44	.0860	80	.0020	.0880	74
4-48	43	.0890	71	.0020	.0910	65
	2.35 mm	.0925	72	.0020	.0926	72
5-40	42	.0935	68	.0020	.0955	61
	40	.0980	83	.0023	.1003	76
5-44	39	.0995	79	.0023	.1018	71
	38	.1015	79	.0023	.1038	72
6-32	37	.1040	71	.0023	.1063	63
	36	.1065	78	.0023	.1088	72
6-40	7/64	.1095	70	.0026	.1120	64
	34	.1110	83	.0026	.1136	75
8-32	33	.1130	77	.0026	.1156	69
	3.40 mm	.1339	74	.0029	.1368	67
8-36	29	.1360	69	.0029	.1389	62
	29	.1360	78	.0029	.1389	70
10-24	3.5 mm	.1378	72	.0029	.1407	65
	26	.1470	79	.0032	.1502	74
10-32	25	.1495	75	.0032	.1527	69
	22	.1570	81	.0032	.1602	73
12-24	21	.1590	76	.0032	.1622	68
	17	.1730	79	.0035	.1765	73
12-28	16	.1770	72	.0035	.1805	66
	16	.1770	84	.0035	.1805	77
1/4-20	15	.1800	78	.0035	.1835	70
	8	.1990	79	.0038	.2028	73
1/4-28	7	.2010	75	.0038	.2048	70
	5.40 mm	.2126	81	.0038	.2164	72
5/16-18	3	.2130	80	.0038	.2168	72
	F	.2570	77	.0038	.2608	72

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5/16-24	6.60 mm	.2598	73	.0038	.2636	68
	H	.2660	86	.0041	.2701	78
	I	.2720	75	.0041	.2761	67
3/8-16	5/16	.3125	77	.0044	.3169	72
	O	.3160	73	.0044	.3204	68
3/8-24	21/64	.3281	87	.0044	.3325	79
	Q	.3320	79	.0044	.3364	71
7/16-14	23/64	.3594	84	.0046	.3640	79
	U	.3680	75	.0046	.3726	70
7/16-20	W	.3860	79	.0046	.3906	72
	25/64	.3906	72	.0046	.3952	65
1/2-13	10.5 mm	.4134	87	.0047	.4181	82
	27/64	.4219	78	.0047	.4266	73
1/2-20	29/64	.4531	72	.0047	.4578	65
9/16-12	15/32	.4688	87	.0048	.4736	82
	31/64	.4844	72	.0048	.4892	68
9/16-18	1/2	.5000	87	.0048	.5048	80
	33/64	.5156	65	.0048	.5204	58
5/8-11	17/32	.5313	79	.0049	.5362	75
5/8-18	9/16	.5625	87	.0049	.5674	80
	37/64	.5781	65	.0050	.5831	58
3/4-10	41/64	.6406	84	.0050	.6456	80
	21/32	.6563	72	.0050	.6613	68
3/4-16	11/16	.6875	77	.0050	.6925	71
	17.5 mm	.6890	75	.0050	.6940	69
7/8-9	49/64	.7656	76	.0052	.7708	72
7/8-14	51/64	.7969	84	.0052	.8021	79
	13/16	.8125	67	.0052	.8177	62
1-8	55/64	.8594	87	.0059	.8653	83
	7/8	.8750	77	.0059	.8809	73
1-12	29/32	.9063	87	.0059	.9122	81
	59/64	.9219	72	.0060	.9279	67
1-14	59/64	.9219	84	.0060	.9279	78
1-1/8-7	63/64	.9844	76	.0067	.9911	72
1-1/8-12	1-1/32	1.0313	87	.0071	1.0384	80
	1-3/64	1.0469	72	.0072	1.0541	66
1-1/4-7	1-1/8	1.1250	67	Reaming Recommended		
1-1/4-12	1-11/64	1.1719	72	Reaming Recommended		
1-3/8-6	1-7/32	1.2188	72	Reaming Recommended		
1-3/8-12	1-19/64	1.2969	72	Reaming Recommended		
1-1/2-6	1-11/32	1.3438	72	Reaming Recommended		
1-1/2-12	1-27/64	1.4219	72	Reaming Recommended		